

**MANUFACTURE OF PROPULSION TUBE**

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**Uittreksel**

**PURPOSE:** To obtain the more economical manufacturing method of a propulsion tube by a method wherein a stock tube having thin-walled tube ends is produced by extrusion molding and, after that, thin-walled parts are formed on inner surface side or outer surface side of the tube by forming the ends of the stock tube.

**CONSTITUTION:** The haul-off speed of a haul-off machine 22 is increased or the extrusion rate of an extruder 18 is decreased or the like at every certain period relative to the extrusion speed of the extruder 18 so as to produce thin-walled parts 26 at fixed intervals to the long direction of a pipe 24. By cutting apart the pipe 24 nearly at the middle part (a) of each thin-walled part 26, stock tubes 10 are obtained. Next, a mold 12, the inner surface form of which is nearly the same form as the end part form of a propulsion tube 28 to be manufactured, is prepared. After that, the thermally softened thin-walled part 26 of the stock tube 10 is forced in the mold 12 so as to be formed. By forming both the end parts of the stock tube 10 as just mentioned above, a propulsion tube having thin-walled parts 14 on the inner surface side at both the end parts. By means of a collar 30 installed on the outer surface of the thin-walled part 14, the propulsion tube 28 is joined with another propulsion tube 28. As no cutting work is necessary in the above-mentioned method, economical efficiency is improved.

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Gegevens geleverd door esp@cenet - I2

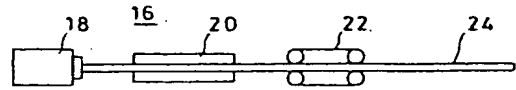
第10図は従来技術を示す図解図である。

第11A図および第11B図は他の従来技術を示す図解図であり、第11A図は断面図、第11B図は第11A図におけるB-B線断面図である。

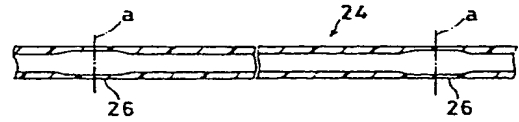
図において、10は原管、12、12'は金型、14、14'は減肉部、16は押出成型システム、18は押出機、20は冷却器、22は引取機、24はパイプ、26、26'は肉厚減少部、28、32、34は推進管、30、30'はカラーを示す。

特許出願人 株式会社 クボタ  
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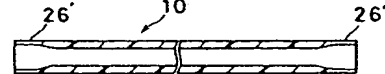
第1図



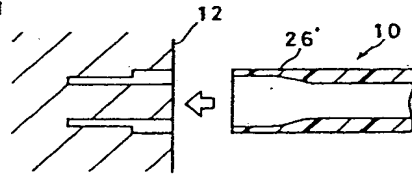
第2図



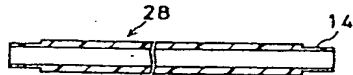
第3図



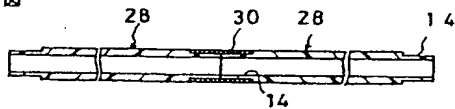
第4図



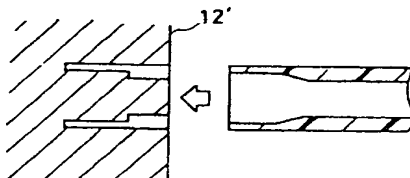
第5図



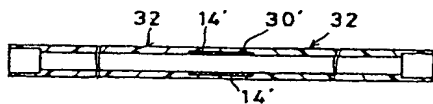
第6図



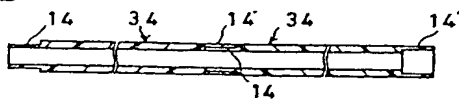
第7図



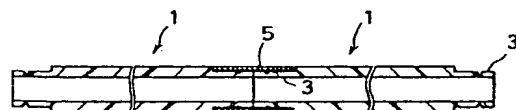
第8図



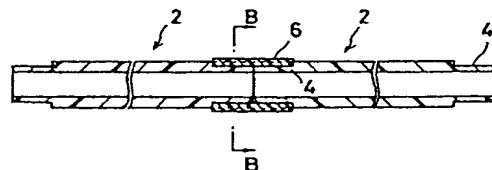
第9図



第10図



第11A図



第11B図

